



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18717-23
Job Sheet 195371



Part No: RBT18717-23

Job Qty: 4 pcs

Part Name: Ratchet Head



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/21/19

Job Tracking No:

Due Date: 6/7/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18717 Rev 1B IPP Rev. A 19.05.10 New issue DP Verify DD

Ship Via:

Bill of Materials



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S192615



Part: RBT18717-23

Job No: 195371

Serial No/Batch: S192615

Revision: 1B

Inspector:

Exp Date:

Instructions:

Date: 06/21/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Handfinish - 7 - BeadBlast	4 pcs	6/7/19	6/7/19	0.00	1.00	Handfinish - 7 - 1		BEB 19-06-21
							Handfinish - 7 - 2		
100	Small Fab - 2 - B4B	4 pcs	6/7/19	6/7/19	0.00	0.27	Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
110	QC 5	4 pcs	6/7/19	6/7/19	0.00	0.00	QC 5 - 10		DAS 40 JUN 24 2019-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	4 pcs	6/7/19	6/7/19	0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	4 pcs	6/7/19	6/7/19	0.00	0.00	QC 21 - SA - 21		DAS 70 JUN 27 2019-89
							QC 21 - SA - 70		
							QC 21 - SA - 53		

Part Op 90 - 1-Measure out 1.250". 2-Mask off 0.750" of forward end of wrench. ***Do not remove chrome from forward end of Descriptions: wrench*** 3-Remove 0.5" of chrome on aft end of wrench. Only remove at area to be welded, not on piece that will be discarded.

100 - 1-Cut wrench as per drawing. 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
05045174	Mini Tatchet, 3-3/4"	4 Ea (1 ea)	90-Handfinish - 7 - BeadBlast	M.U. 010528 5184029.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Handfinish - 7 - BeadBlast	05045174	4	1	0

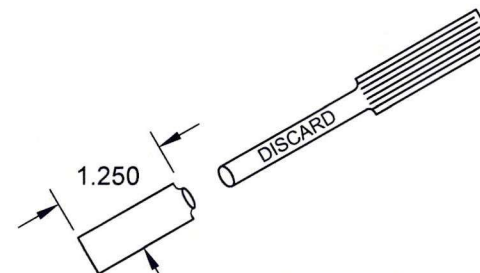
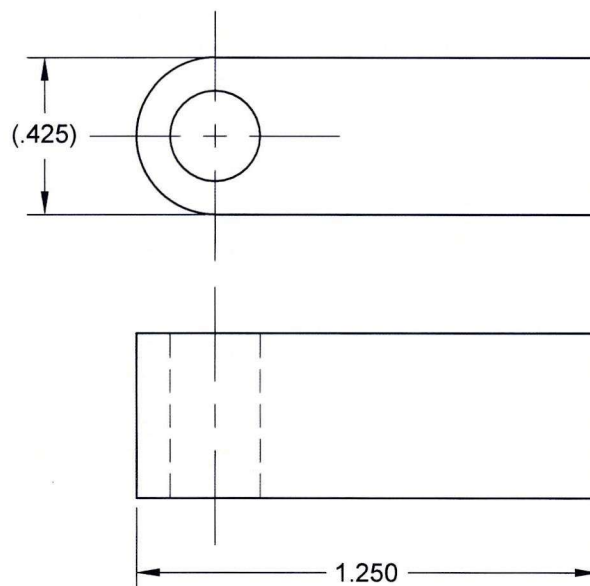
Part Specifications

Specifications could not be found.

Plex 5/21/19 10:31 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D P/N -11 & -19 DIM 1.625 TO 1.578 PER D.W. & RATCHET HANDLE CUT OFF DIM 1.375 TO 1.250.	10/14/09	RJC	RW



CUT OFF RATCHET HANDLE AS SHOWN, FLIP RATCHET HEAD TO THE L/H ROTATION POSITION FOR WELDING.

NOTE:
REMOVE MANUFACTURE INFO, LEAVE TORQUE INFO.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195371 MGS

1905-21

(-23)
RATCHET
HEAD

DART AEROSPACE	
TITLE WRENCH SET, COMPRESSOR CASE	
DWG NO. RBT18717-23	REV 1B
MAT'L	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/32 .XX ± .03 ANGLES ± 5° X ± .1	APPROVED <i>D. West</i> HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL R.R. 250
SCALE 2:1	DATE 8-26-09
SHEET 9 of 11	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :		Sequence #:		QTY Affected :		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					